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Work Order ID 160928

Friday, May 05, 2017 10:19:19 AM

160928

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Item ID: D4950-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Tailboom Mount
Start Date: 5/23/2017 Start Qty: 4.00 *4*7
Required Date: 5/29/2017 Req'd Qty: 4.00 *4*
Reference: SCHEDULED/C

Approvals: Process Plan: [Signature] Date: MAY 05 2017 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4950	B ✓								
100		0.00							
100	Small Fab								
Small Fab	Memo	1.61							
Small Fab	1- Assemble with a thin layer of Proseal between the mating surfaces as per dwg D4950 A/R Proseal 890 batch: 136953								
110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
113		0.00							
113									
SprayPaint	Memo	0.00							
Spray Painting	Prime as per dwg and OSI A/R Primer Batch: 136615								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
37								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

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Page 2

Item ID: D4950-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tailboom Mount
Start Date: 5/23/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 5/29/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115 *115* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				7			DAS 38 9-89 MAY 24 2017
120 *120* Packaging Packaging	Identify as per dwg & Stock Location: <u>5H139</u> Memo	0.00 0.00				7			MAY 24 2017 DAS 6 9-89
130 *130* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							17/5/25 <i>[Signature]</i> DAS 21 9-89 MAY 24 2017

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : 	
Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Work Order ID: 160928

160928

Parent Item: D4950-041

D4950-041

Parent Item Name: Tailboom Mount

Start Date: 5/23/2017

Required Date: 5/29/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.09.24 NEW ISSUE DD VERF:JLM
REV:B 14.01.16 AS PER DWG REV.B DD VERF:JLM

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4950-1 *D4950-1* Mount		Manufactured	No			100	Each	2.0000	1	4 7 160953		DAS 6 9-89	MAY 15 2017
				<u>Location</u>				<u>Loc Qty</u>					
				ST139				2					
				152147				2		2			
D3868-1 *D3868-1* Spacer		Manufactured	No			100	Each	15.0000	2	8-14		DAS 6 9-89	MAY 15 2017
				<u>Location</u>				<u>Loc Qty</u>					
				ST054				15		6			
				111657				15		8			
MS20426AD3-6 *MS20426AD3-6* Rivet		Purchased	No			100	Each	2,240.000	4	1628		DAS 6 9-89	MAY 15 2017
				<u>Location</u>				<u>Loc Qty</u>					
				GA				1304					
				M133988				1304					
				ST312				936		28			
				M133988				936					

4533
28 DAS
36
9-89

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OTHER : ☐									